

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008542**Date Inspected:** 30-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower&OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY#11

Magnetic Particle Inspection

This Q.A Inspector performed Magnetic Particle Testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the West Tower, Lift2,and Skin E the welds Designation are as follows.

WSD1-FESA3-2C/D-1, 2, 5; WSD1-FESA3-2D/D-1, 2, 9, 10, 11, 14

This QA Inspector randomly observed the following work in progress

BAY#10

SAW welding process of weld joint 2B located on PCMK NSD1-A112B/H. Welder is identified as 040489
ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the
WPS-B-T-2221C-U2B-S-2

WELDING INSPECTION REPORT

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SAW welding process of weld joint 124B located on PCMK NSD1-A166E/J. Welder is identified as 201750 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221C-U2B-S-2

BAY#11

SAW welding process of weld joint 5 located on PCMK WSD1-FDSA3-2C/C. Welder is identified as 068047 ZPMC QC is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F

SAW welding process of weld joint 10 located on PCMK WSD1-FDSA3-2C/C. Welder is identified as 066484 ZPMC QC is identified as Cao Cheng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2333-TC-P4-F

SAW welding process of weld joint 4A located on PCMK WSD1-TL6B/L. Welder is identified as 0640634 ZPMC QC is identified as Yun Xiaw. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S.

OBG TRIAL ASSEMBLY YARD

Visual Inspection

This Caltrans Quality Assurance (QA) Inspector observed ZPMC performing plug welding of abandoned bolt holes without an approved welding procedure specification (WPS) on stiffener # 3 near panel point 24 of segment 4AE in OBG Trial Assembly Yard. ZPMC Quality Control (QC) CWI Inspectors were not present during the welding operations

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer